

Work Order ID 56582

March 1, 2010 2:50:32 PM

Page 1

PROTOTYPE



Item ID: D3785-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 3/01/10

Start Qty: 1.00



Cust Item ID:

Required Date: 3/10/10

Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: u

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3785

Rev D

Rev. B per prototype

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3785

Dwg Rev: 3

Prog Rev: 3

****grain direction 45 degree****

2- Deburr if necessary

Hand make Rev. B

B 10-3-3

③

6061 . 080

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-3-3

Work Order ID 56582

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

3

10/03/03

130

NC BRAKE

0.00



Brake NC

Memo

0.00

Brake NC

Bend as per Dwg D3785

*Rev. B**SP 10/03/03*

3

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

3

10/03/03

Work Order ID 56582

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Item ID: D3785-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 3/01/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/10/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-counter sink holes as per dwg D3785								
160 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
170 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

Handwritten signature and date 3/5/03/04 with circled 3

Handwritten number 3 and signature J00305

Handwritten initials ML and date 10/03/05

Handwritten circled X3 and a circle with a slash

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the work.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete them.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress to ensure that the objectives are being met.

5. Finally, the fifth step is to evaluate the results of the project. This involves assessing the outcomes against the objectives and identifying any areas for improvement or further action.

Page 4

(b) (5) DPP, (b) (7)(C), (b) (7)(D)

Setup Start[illegible]

Stop

1. The first step is to identify the problem or question that needs to be addressed. This involves understanding the context and the specific requirements of the task.

2. The second step is to gather relevant information and resources. This may involve research, consultation with experts, or reviewing existing data.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the sequence of actions to be taken.

4. The fourth step is to implement the plan. This involves carrying out the tasks identified in the plan and monitoring progress as the work progresses.

5. The fifth step is to evaluate the results and make adjustments as needed. This involves comparing the actual outcomes with the expected results and identifying any areas for improvement.

6. The final step is to document the process and results. This involves creating a record of the work done, the challenges encountered, and the solutions found, which can be used for future reference.

Cust Item ID:

Customer:

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

Abstract

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

BR 10-3-5. (3)

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

QC

Memo

0.00

Quality Control

\Rightarrow $10/03/08$ $\textcircled{X3}$ $\cancel{\emptyset}$

Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:00 AM
OVEN TEMPERATURE: 320°
FINISH TIME: 10:30 AM

0.00

1. The first step in the process is to identify the problem. This involves gathering information about the situation and understanding the needs of the stakeholders involved.

2. Once the problem is identified, the next step is to develop a plan. This involves setting goals, identifying resources, and determining the steps that need to be taken to address the problem.

3. The third step is to implement the plan. This involves putting the plan into action and monitoring progress to ensure that the goals are being met.

4. Finally, the fourth step is to evaluate the results. This involves assessing the effectiveness of the plan and making adjustments as needed to improve the outcome.

QC

Memo

0.00

Quality Control

Work Order ID 56582

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Item ID: D3785-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 3/01/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/10/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

Mike P.

0.00

Not for sale

Packaging

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

~~ENG~~ 0100 MAR

PROTOTYPE

-- ME
10-3-10

Picklist Print

March 1, 2010 2:50:31 PM

Page 1

Work Order ID: 56582

Parent Item: D3785-3

Parent Item Name: Bracket

Comments: IPP Rev:A 08-05-01 new issue DD verified by:EC
IPP Rev:B 09-01-09 rev.B as per dwg DD verified by:ec

Start Date: 3/01/10

Required Date: 3/10/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	141.3597	0.3139			



6061-T6 .080 Sheet



B10-3-3

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

141.35967

110630

35.0136

112141

0.86727

112763

6.85

113438

98.6288

3

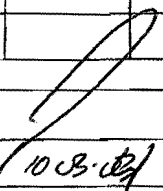
113438

DART AEROSPACE LTD		Work Order: 56582
Description: BRACKET		Part Number: D 3785-3
Inspection Dwg: D3785-3 Rev: B		Page 1 of 1

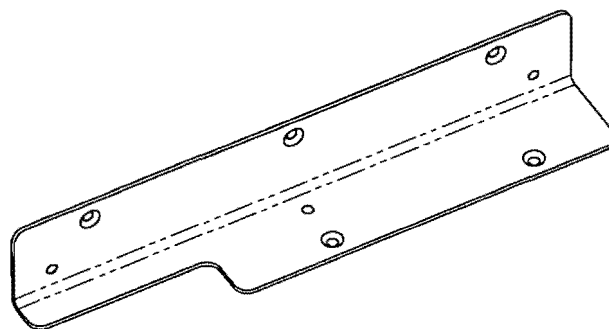
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .201	±.005 - .001	.204	✓			
4.000	±.010	3.998	✓			
4.000	±.010	3.998	✓			
1.500	±.010	1.502	✗			
.375	±.010	.377	✗			
2.689	±.010	2.689	✓			
3.44	±.030	3.445	✓			
.750	±.010	.751	✗			
9.500	±.010	9.502	✗			
7.50	±.030	7.507	✓			
11.00	±.030	11.007	✓			
1.220	±.010	1.222	✗			
2.219	±.010	2.220	✗			
2.44	±.030	2.441	✗			
.080	±.010	.079	✗			

Measured by: B	Audited by: 	Prototype Approval:	N/A
Date: 10-3-3	Date: 10-3-04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3785-3 BRACKET

*Wb
56582*

*OK TO MAKE
QTY 1
MP
10/3/11*

RELEASED
08/05/11

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

B	REDESIGNED D3785-3; REMOVED P/Ns D3785-0411-11-51-7; DRAWING TITLE WAS ARMREST WELDMENT REASON: ELIMINATED ARMREST FWD-AFT ADJUSTMENT; PARTS AND WELDMENT NO LONGER REQUIRED	MB	08.07.18
A	NEW ISSUE	MB	08.04.28
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	08.07.18		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3785	REV. B
TITLE BRACKET	SCALE NTS

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